

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008854**Date Inspected:** 07-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 5BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG024A-005. The welder is identified as #220066 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231T.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SP305A-001-050 to 063. The welder is identified as #220077 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

Segment 5CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG026A-007. The welder is identified as #220067 and was observed

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welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231T.

Segment 1AW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SSD34-PP8.5-039, 095, 093. The welder is identified as #220069 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4c-F for CWR667.

Segment 2BW

This QA Inspector observed ABF personnel performing MT on stiffener plate hold back welds along the 2BW/3AW transverse field splice connection.

Segment 1BE

This QA Inspector observed ZPMC personnel perform MT of side plate stiffener hold back welds along the 1BE/2AE transverse field splice connection.

ZPMC Quality Control (QC) Inspector is identified as Chen Bo and Feng Ya Jun. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 1AAE/1AE

This QA Inspector was setting up to perform MT of the 1AAE/1AE transverse CJP segment splice when ZPMC personnel entered the segment telling us not to MT the weld, only UT could be performed at this time. QA Inspector Joe Alaniz had already begun to perform MT of the interior side of the splice weld at the deck panel location working on the scaffolding. ZPMC personnel went up on the scaffolding with UT couplant and a ZPMC UT technician present to perform UT of the splice weld in attempt to stop the QA MT in progress. At this time ZPMC personnel unplugged the power supply and threw it off the scaffolding telling us to leave the segment. One of the ZPMC employees attempted to leave with the power chord. This QA Inspector attempted to tell him the power chord belonged to Caltrans personnel. The ZPMC employee began to exit the segment when this QA Inspector pulled the chord away from the ZPMC employee. This QA Inspector called Lead Inspector Mark Miller of the situation. ZPMC personnel continued to tell the QA Inspectors to leave the segment. This QA Inspector and QA Inspector Mr. Alaniz gathered our equipment to exit the segment during this time one of the ZPMC employees grabbed QA Inspector Mr. Alaniz arm. This QA Inspector called QA Inspector Sandeep Kumar to stop MT at this time on the exterior splice weld on the deck plate. At this time QA Inspector Mr. Kumar stated his power chord had been unplugged. This QA Inspector, QA Inspectors Mr. Alaniz and Mr. Kumar exited the segment at this time.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

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No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
